

Work Order ID 50651

July 20, 2009 9:11:25 AM



Page 1

Item ID: D2282-043

Accept



Setup Start



Revision ID: E

Stop



Item Name: Saddle Assembly

Start Date: 07/20/2009 Start Qty: 50.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly: A/RER316L SS

Filling

Rod: H108775

Dwg Rev: E

M 102421

sp. 09.07.24.

P10 →

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- grind weld flush, take all welding marks out and deburr holes

m-h 09/07/30

50x

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo


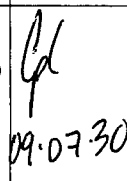
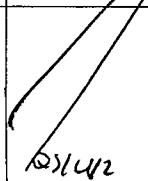
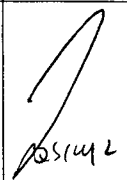
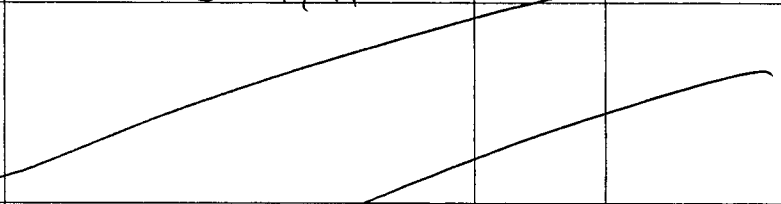
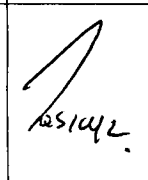
0.00

Quality Control

09.07.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2282-043 PAR #: N/A Fault Category: hge FAB NCR: (Yes) No DQA: A Date: 09.08.11
SCRAP / SCRAP QA: N/C Closed: / Date: 02.08.17

NCR: 50651		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/30	#1 Large FAB.	Found Qty x1 Parts with the Dim between 2.409" between inside between D2282-7's Also D2282-041		part could be ground down, but due to replacement parts being unavailable. part is to be scrap, destroyed: replaced . no replace. Qty x1	 09.07.30	S 02/07/30		S 09/07/30
		will not pass through the gap gap measures about 2.360". R.C. not welded in correct location. less						S 09/07/30

NOTE: Date & initial all entries

Work Order ID 50651

July 20, 2009 9:11:25 AM



Page 2

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Revision ID: E

Stop



Item Name: Saddle Assembly

Start Date: 07/20/2009 Start Qty: 50.00



Cust Item ID:

Required Date: 07/20/2009 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 802/07/30

count 80
x 49

40

40

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-tumble

8 9-8-4

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 802/08/04

count 80
x 49

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50651

July 20, 2009 9:11:25 AM



Item ID: D2282-043
Revision ID: E
Item Name: Saddle Assembly

Accept



Setup Start
Stop



Start Date: 07/20/2009 Start Qty: 50.00

Required Date: 07/20/2009 Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 261

0.00



Packaging

Memo

0.00

Packaging

1/8/24

SP

6/8/24

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

7/20/09
1/8

u 21.06.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 20, 2009 9:11:25 AM

Work Order ID: 50651

Parent Item: D2282-043RevE

Parent Item Name: Saddle Assembly



Comments:

Start Date: 07/20/2009

Required Date: 07/20/2009

Start Qty: 50.00

Required Qty: 50.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2281RevG		Manufactured	No			100	Each	25.0000	50.0000			
												
Jack Saddle												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>	<i>\$0658</i>	
Main Warehouse	<i>22281</i>	<i>59</i>
ST	25	
46831	25	

25

25

SP 09.07.21

D2282-7RevE		Manufactured	No			100	Each	202.0000	100.0000			
												
Tube												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	202	
46690	150	
48283	52	

100

SP 09.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval/ QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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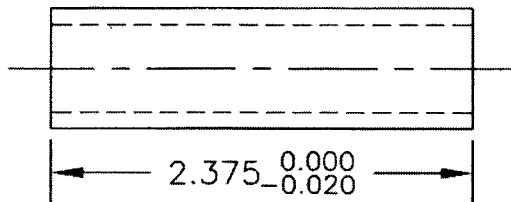
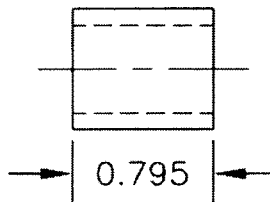
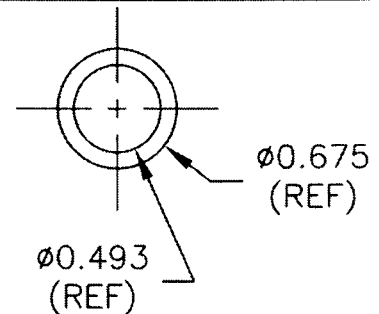
NOTE: Date & initial all entries

DART

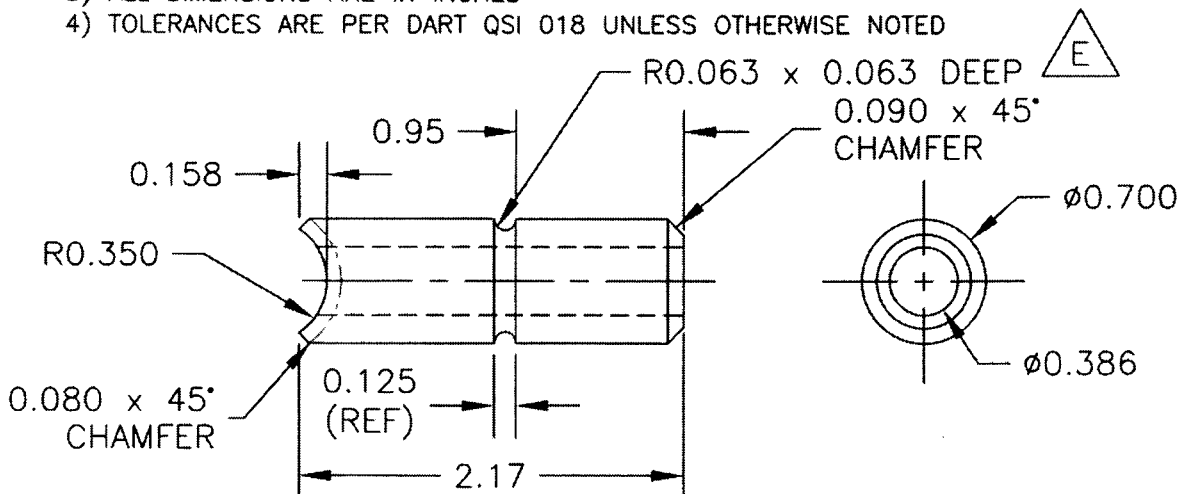
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CHECKED <i>ip</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

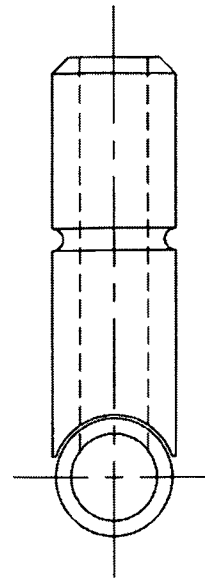
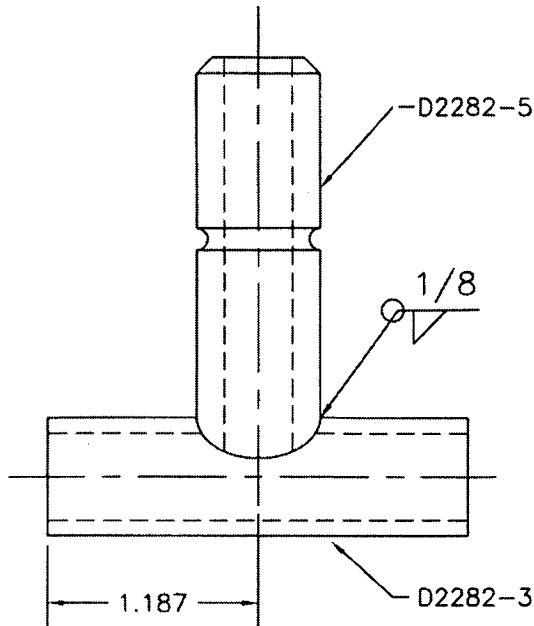
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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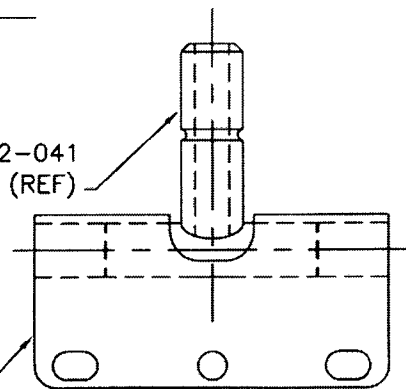
NOTE: Date & initial all entries

DART

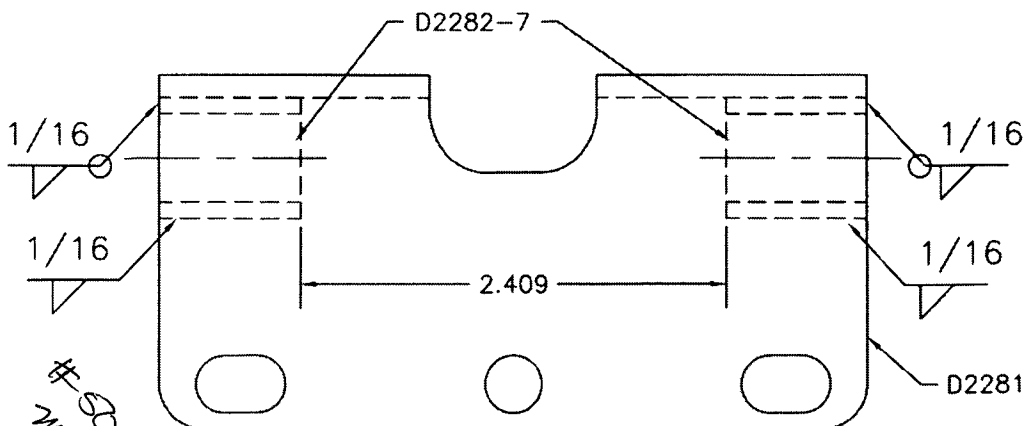
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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#80657
W/F 09-07-20
02-10-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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